










Date: Wednesday, 11/03/2009 9:19:07 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 46408		
Estimate Number	: 10346		
P.O. Number	:	Part Number	: D2596
This Issue	: 11/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2596 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	: 45876	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>JUD 09.03.11</u>	Due Date	: 18/03/2009
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -I" Beam Web 4"	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 ' Extrusion B 40196			
M ^c 09-03-11			
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
> M ^c 09-03-11			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
M ^c 09-03-11			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
9-3-11 (8)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SKID tube cell

MB

09-03-11

(8)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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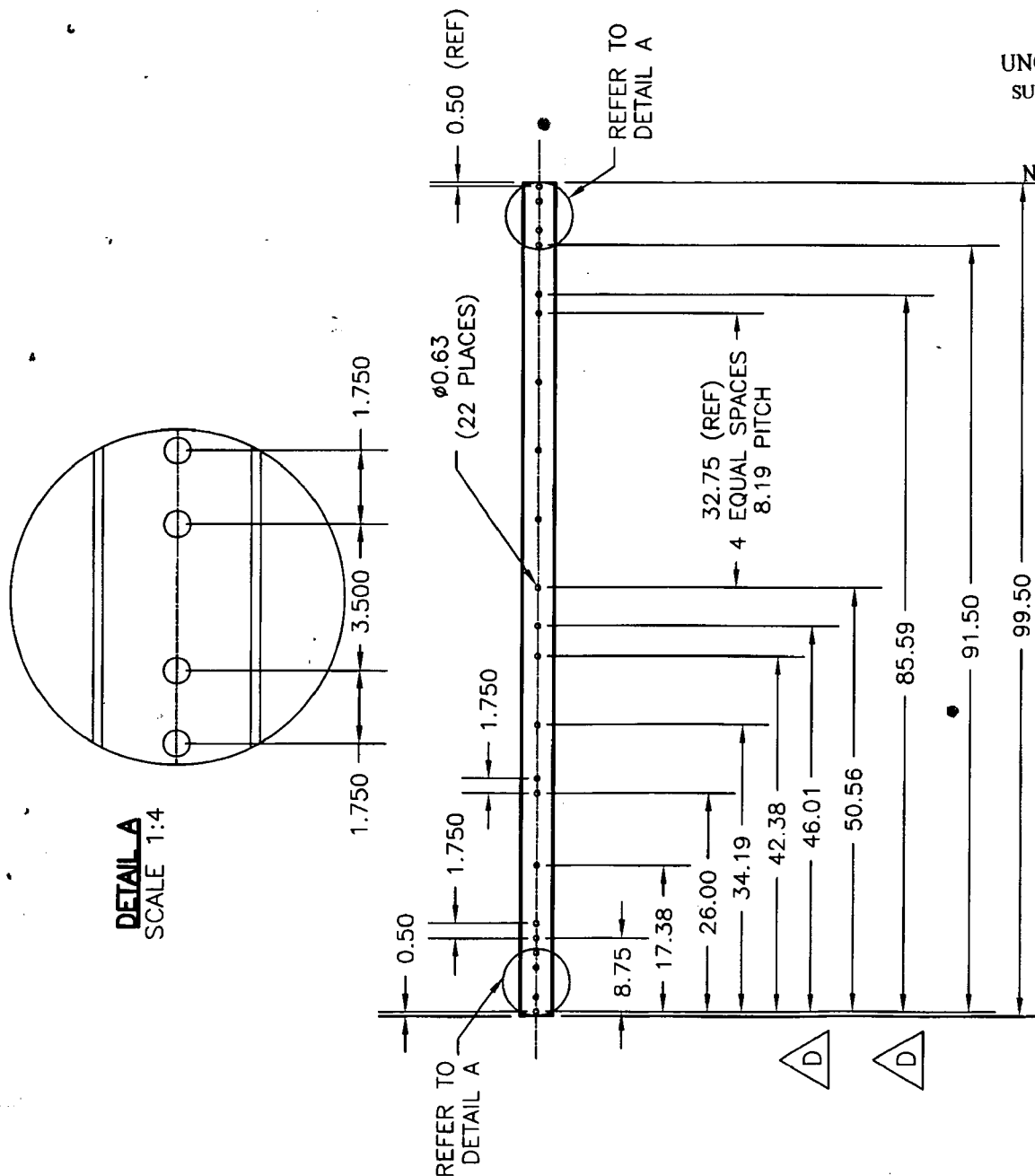
NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>		DRAWN BY <i>PH</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. REV. D D2596 SHEET 1 OF 1	
DATE 07.04.17		TITLE SCALE 205 WEB 1:20			
A	96.09.16	NEW ISSUE			
B	97.07.23	ø0.63 HOLE WAS ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

RELEASED
07-06-28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46408



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

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